

76913

Work Order ID 86331

86.331

Page 1

Item ID: D2620

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube, 206 Skidtube

Start Date: 27/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12/06/27 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2620

Rev B

100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program
206.A and Folio 15-0002 Cut Fwd end of tube as per Dwg D2620

15

>

CF 12-6-28

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

DP 12-6-28

120

Identify as per dwg & Stock Location: 46

0.00

120

Packaging

Memo

0.00

Packaging

DP 12-6-28

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86331***86.331***

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June-27-12 1:26:47 PM

Item ID: D2620

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube, 206 Skidtube

Start Date: 27/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00


130

QC

Memo

0.00

Quality Control

12/6/29 MF
12-06-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-27-12 1:26:52 PM

Page 1

Work Order ID: 86331

86331

Parent Item: D2620

D2620

Parent Item Name: Skidtube, 206 Skidtube

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP D02.07.26Change Dwg to rev.B; Updated LocationRF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-160		Manufactured	No			100	Each	75.0000	1	20			

D2600-1-160

Extrusion Round 3" 206

**

DP 12-6-28

Location

Loc Qty

Loc Code

LG

75

43969

2

59875

1

68284

4

76913

68

20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY

RETURN TO

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 06331 MLD

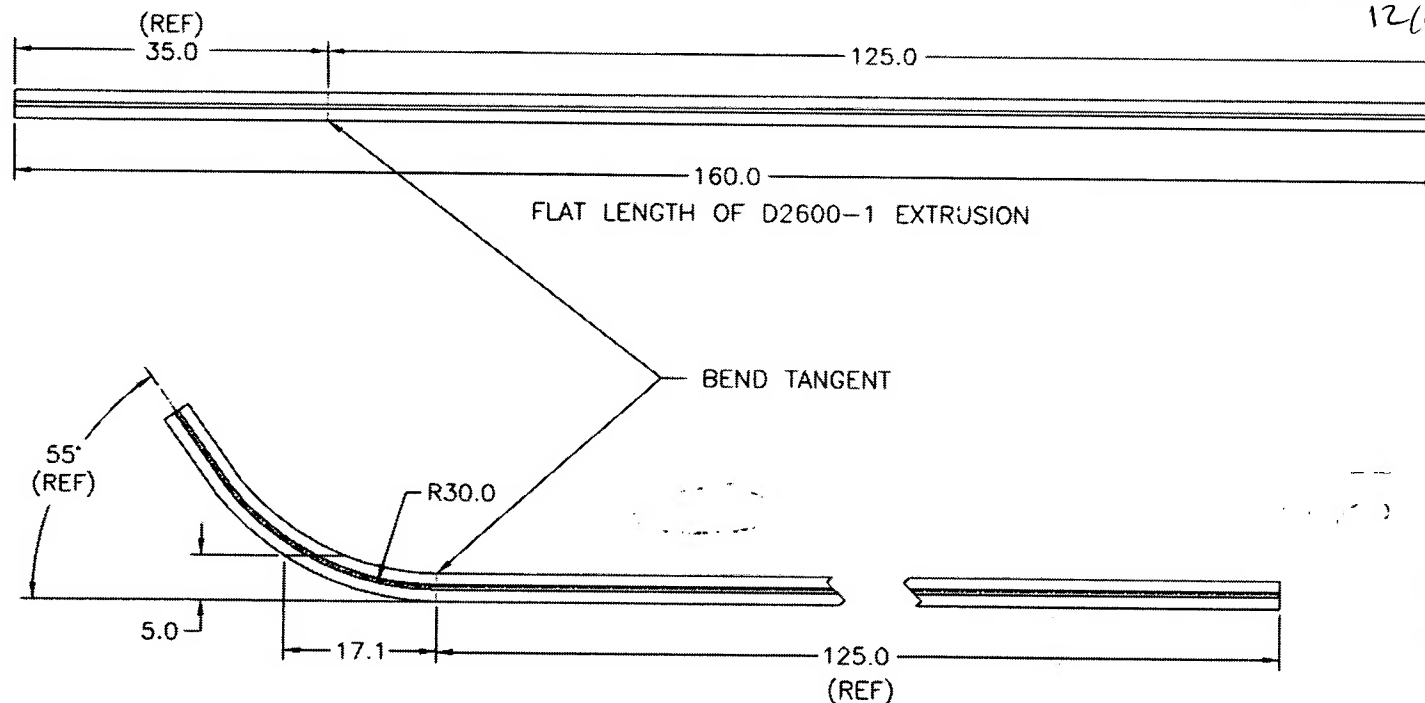
12/06/27

DART



SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

RELEASED
99.04.15 DS

DESIGN	DRAWN BY	TITLE	SCALE
99.09.10	RF	206 SKIDTUBE BENDING CONTROL	1:20
CHECKED	APPROVED	DRAWING NO. D2620	REV. B
DATE	DATE	DATE	SHEET 1 OF 1
99.09.10	97.11.07	97.09.10	
A	NEW ISSUE	UPDATE FOR IN-HOUSE BENDING	
B			

DART AEROSPACE USA, INC.
FAIRCHILD INTERNATIONAL AIRPORT, WA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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